

Date: Monday, 6/19/2006 11:30:53 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT
Job Number	: 27647		
Estimate Number	: 10273		
P.O. Number	: N/A	Part Number	: D2565101
This Issue	: 6/19/2006	S.O. No. :	N/A
Prsht Rev.	: NC	Drawing Number	: D2565 REV E
First Issue	: N/A	Project Number	: N/A
Previous Run	: 27165	Drawing Revision	: E
Written By	: <u>                    </u>	Material	: N/A
Checked & Approved By	: <u>                    </u>	Due Date	: 7/10/2006
Comment	: Est: F 02.04.16 Added dwg Rev.C1 NG	Qty:	20 Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 1.7955 f(s)/Unit Total: 35.9100 f(s)

304 RD TUBE .750 X.49W

Material :304/316/318-2B Seamless Tubing, 3/4" O.D. x 0.049" wall per Dwg (M304TR0750W049)

Batch

M 100599 (x1) / M 18983 (x1) / M 100797 (2x) / M 101593 (16x)

FF 06.08.08

20

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Punch as per Dwg D2565 using DT 8313

FF 06.08.08

20

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill hole open to .316 Ø as per Dwg D2565 (one end only)

Deburr and polish

M 1006/08/09

Press MF 06/09-05 (20)

MF 06-09-05 (20)

4.0	QC5	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SB 06/09/06

20

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/09/12

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 27647

Part Number: D2565101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

FC 06 09 08 20

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/09/11 20

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST185

PO 6/09/11 20  
PB 06/09/11 20

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/12 20

Job Completion



u 2009-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

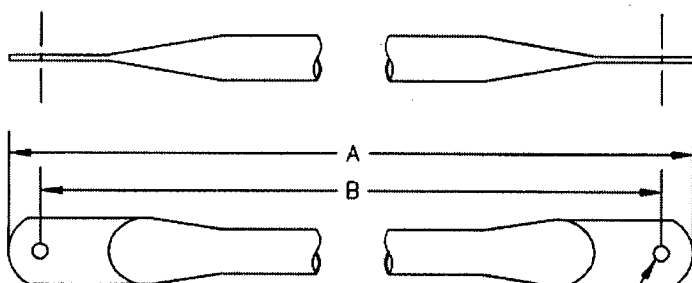
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

**RELEASED**  
04.05.05



DIA 0.257 TO BE PUNCHED  
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

#### GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
(REF DART SPEC. M304TR0.750W0.049)  
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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NO. 27647

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